

**Work Order ID 74908****\*74908\***

Page 1

Thursday, October 13, 2011 11:35:12 AM

Item ID: D4055-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Tank Front and Bottom  
Start Date: 10/13/2011 Start Qty: 5.00 **\*5\*** Cust Item ID:  
Required Date: 10/20/2011 Req'd Qty: 5.00 **\*5\*** Customer:  
Reference:

Approvals: Process Plan: *R* Date: 11-10-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4055	B								

100		0.00							
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**\*100\***

Purchasing Memo 0.00 *M11-10-13*

Purchasing Issue P/O: 15139

Purchase part as per Dwg D4055

Possible Supplier: GFI

Material release note required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
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**\*110\***

Packaging Memo 0.00 *P11/11/11* (5)

Packaging

120	QC6- Inspect dimensions to drawing	0.00							
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**\*120\***

QC Memo 0.00 *S11/11/11* (5)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 74908

**\*74908\***

Page 2

Thursday, October 13, 2011 11:35:13 AM

Item ID: D4055-11 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tank Front and Bottom  
 Start Date: 10/13/2011 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 10/20/2011 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		<i>11-11-07</i>		<u>5</u>	<u><del>0</del></u>		
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>5</u>	<u><i>11-11-7</i></u>		
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>NA</i>  Memo	0.00  0.00		<i>11-11-21</i>		<u>5</u>	<u><del>0</del></u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 74908****\*74908\***

Page 3

Thursday, October 13, 2011 11:35:13 AM

Item ID: D4055-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tank Front and Bottom

Start Date: 10/13/2011 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

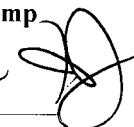
**\*160\***

QC

Memo

0.00

Quality Control

11/11/22 ME  
11-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, October 13, 2011 11:35:16 AM

Page 1

Work Order ID: 74908

**\*74908\***

Parent Item: D4055-11

**\*D4055-11\***

Parent Item Name: Tank Front and Bottom

Start Date: 10/13/2011

Required Date: 10/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11P		Purchased	No			110	Each	0.0000	1	5			
<b>*D4055-11P*</b>									<b>**</b>				
Tank Front and Bottom													

*Comp 11/10 2 (5)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



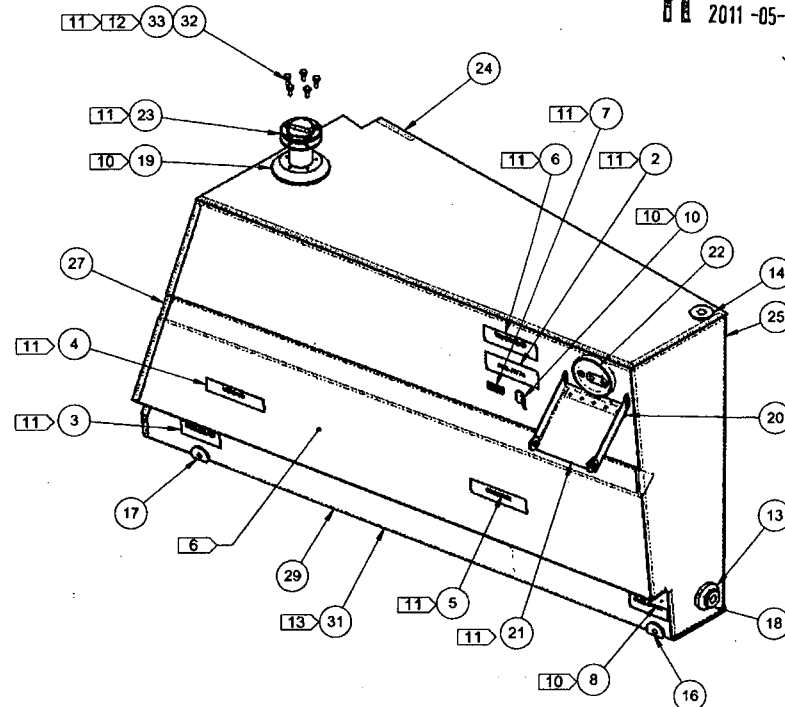
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

## SHOP COPY D4055-041 FUEL TANK ASSEMBLY RETURN TO

ENGINEERING.  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74908 11/10/13



RELEASED  
2011-05-30

B	MOVE CAP POSITION AND CHANGE CAP DESIGN. CHANGE FINISH REQUIREMENTS FOR ALL PARTS. ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	BY	10.04.16
REV.	DESCRIPTION	DATE	
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B
TITLE TANK	SHEET 1 OF 15
	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

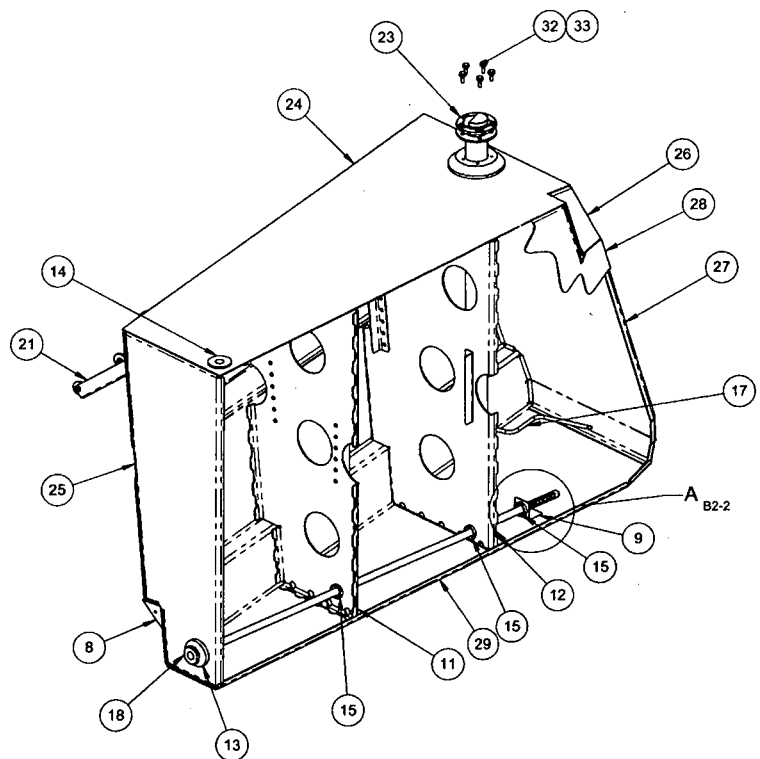
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

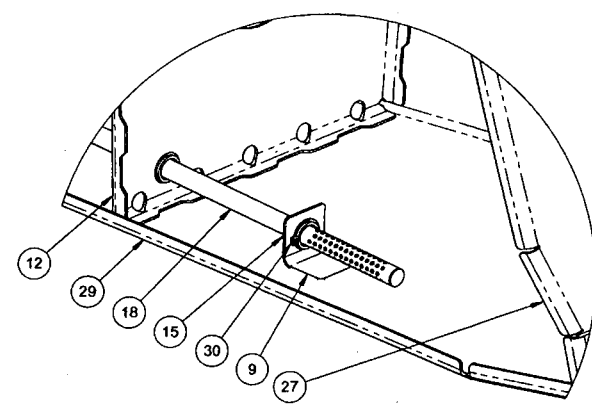
**NOTE:** Date & initial all entries

74806  
74908

**RELEASED**  
2011-05-30  
JND



**D4055-041 FUEL TANK ASSEMBLY**  
**D4055-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**



**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-2

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.		SHEET 2 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	<b>11.05.12</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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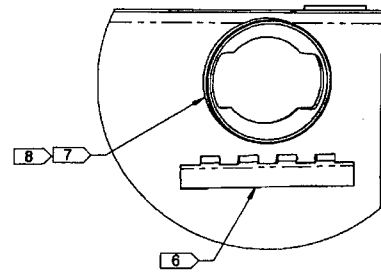
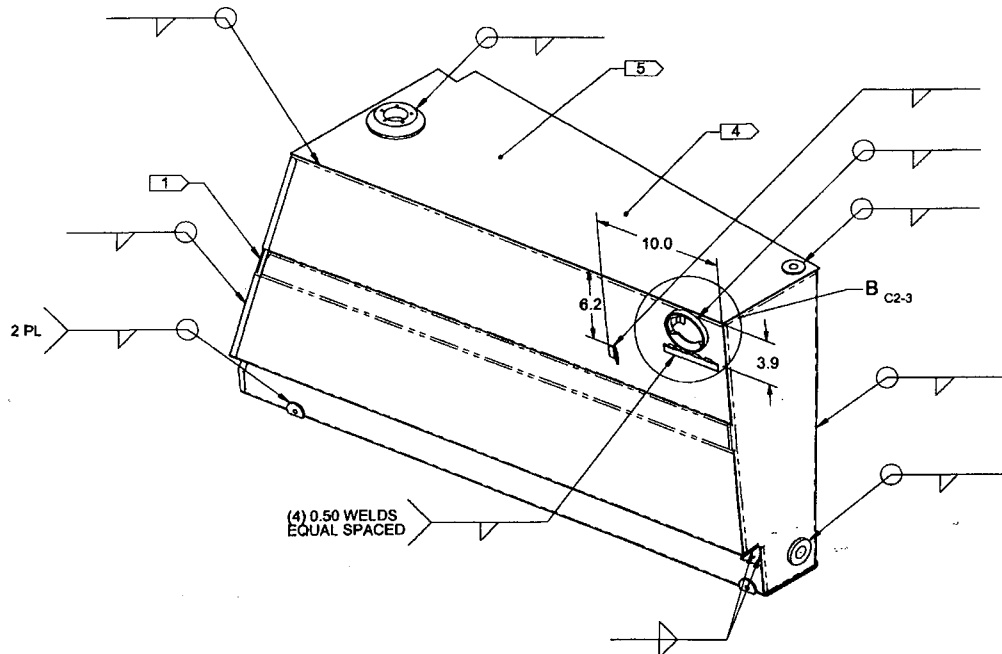
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806  
74908



**DETAIL B**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

C4-3

**D4055-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
  - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP)  $\phi 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

**RELEASED**  
2011-05-30

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JS</i>	<b>D4055</b>	SHEET 3 OF 15
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	<b>TANK</b>	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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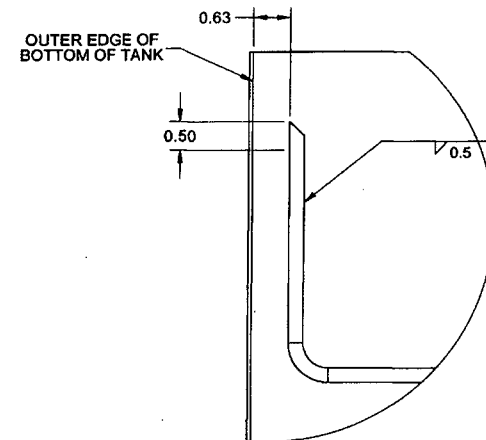
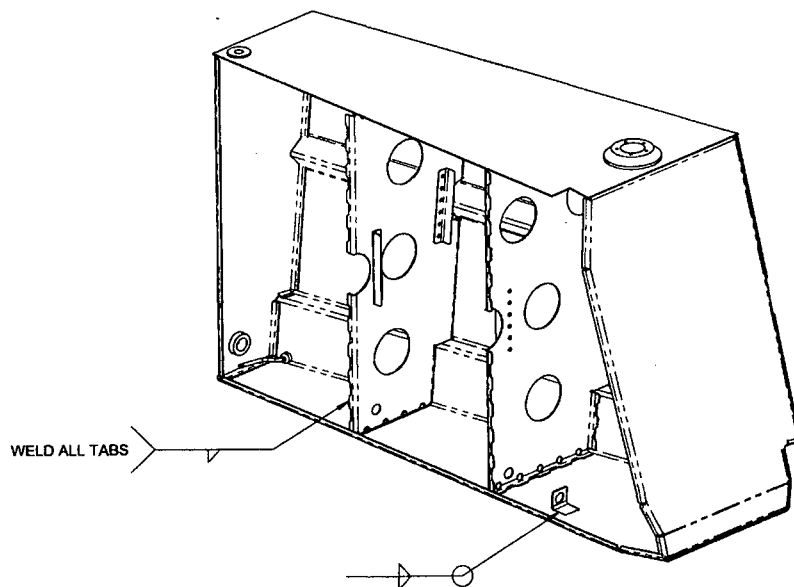
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

74806  
74905



**DRAIN TUBE INSTALLATION - TYP**  
**VIEWED FROM ABOVE**  
**FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**RELEASED**  
2011-05-30  
JMT

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4055</b>	SHEET 4 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>TANK</b>	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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**NOTE:** Date & initial all entries



8 7 6 5 4 3 2 1

D

C

B

A

35.33  
33.36  
32.83  
1.60  
1.81  
Ø2.00  
8.18  
15.75  
9.31  
Ø1.00  
1.25  
0  
1.25

0.063  
REF

**D4055-1 TANK TOP**

**RELEASED**  
2011-05-31  
JUN

**NOTES:**  
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 2.68 lbs

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		
MFG. APPR.		
DE APPR.		
DATE	11.05.12	

DRAWING NO.	REV. B
D4055	SHEET 5 OF 15
TITLE	SCALE
TANK	NTS

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8 7 6 5 4 3 2 1

RELEASE  
2011-05-38  
*W*

**D4055-1 TANK TOP**

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4055</b>  TITLE <b>TANK</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBMITTED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. B
DRAWN	<i>[Signature]</i>		SHEET 5 OF 15
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.05.12		

W/O:		WORK ORDER CHANGES					
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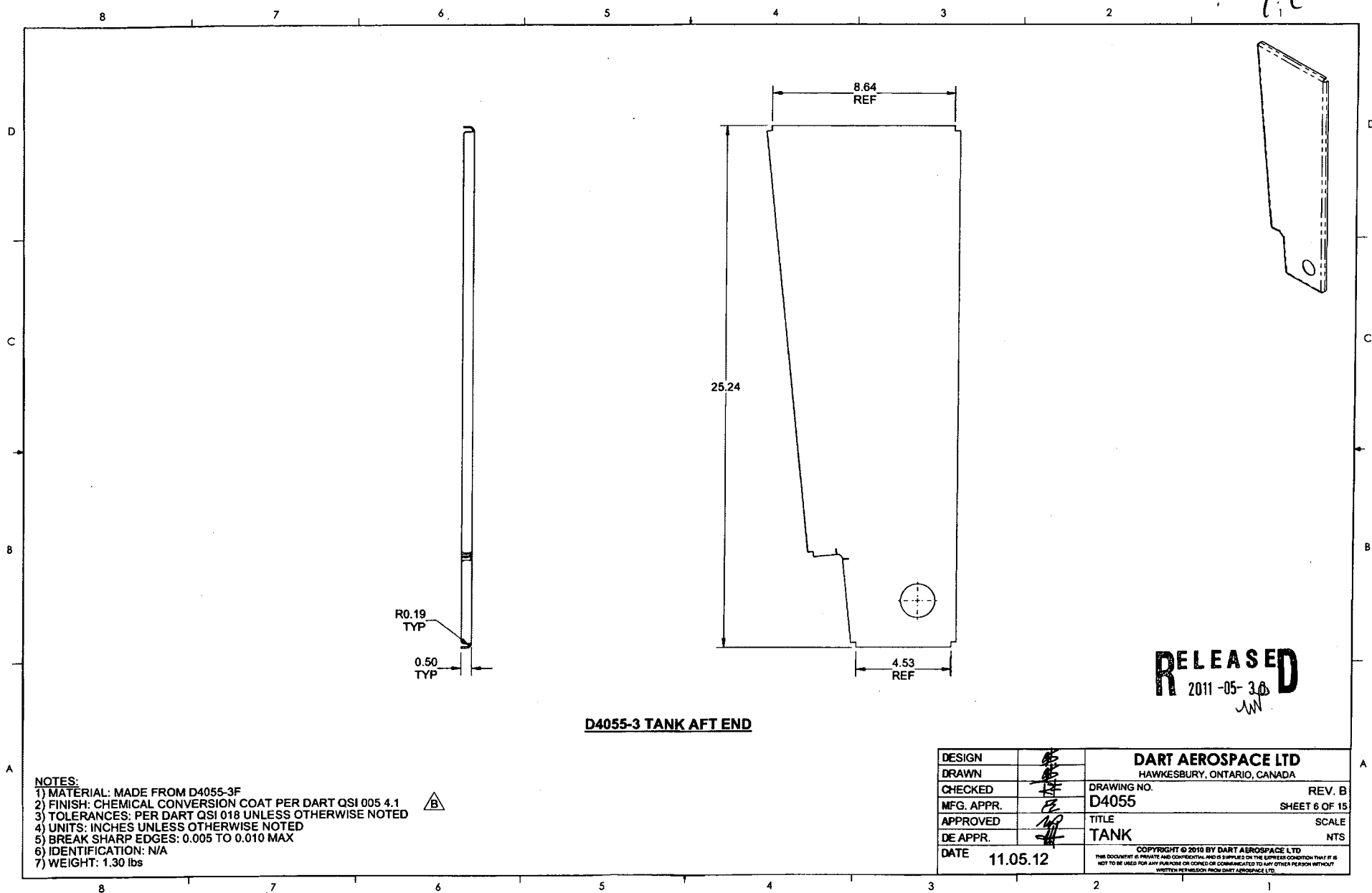
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**NOTE:** Date & initial all entries

74806 74908



**D4055-3 TANK AFT END**

**RELEASED**  
2011-05-30  
JW

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.		SHEET 6 OF 15	
APPROVED		TITLE <b>TANK</b>	SCALE
DE APPR.		NTS	
DATE	<b>11.05.12</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

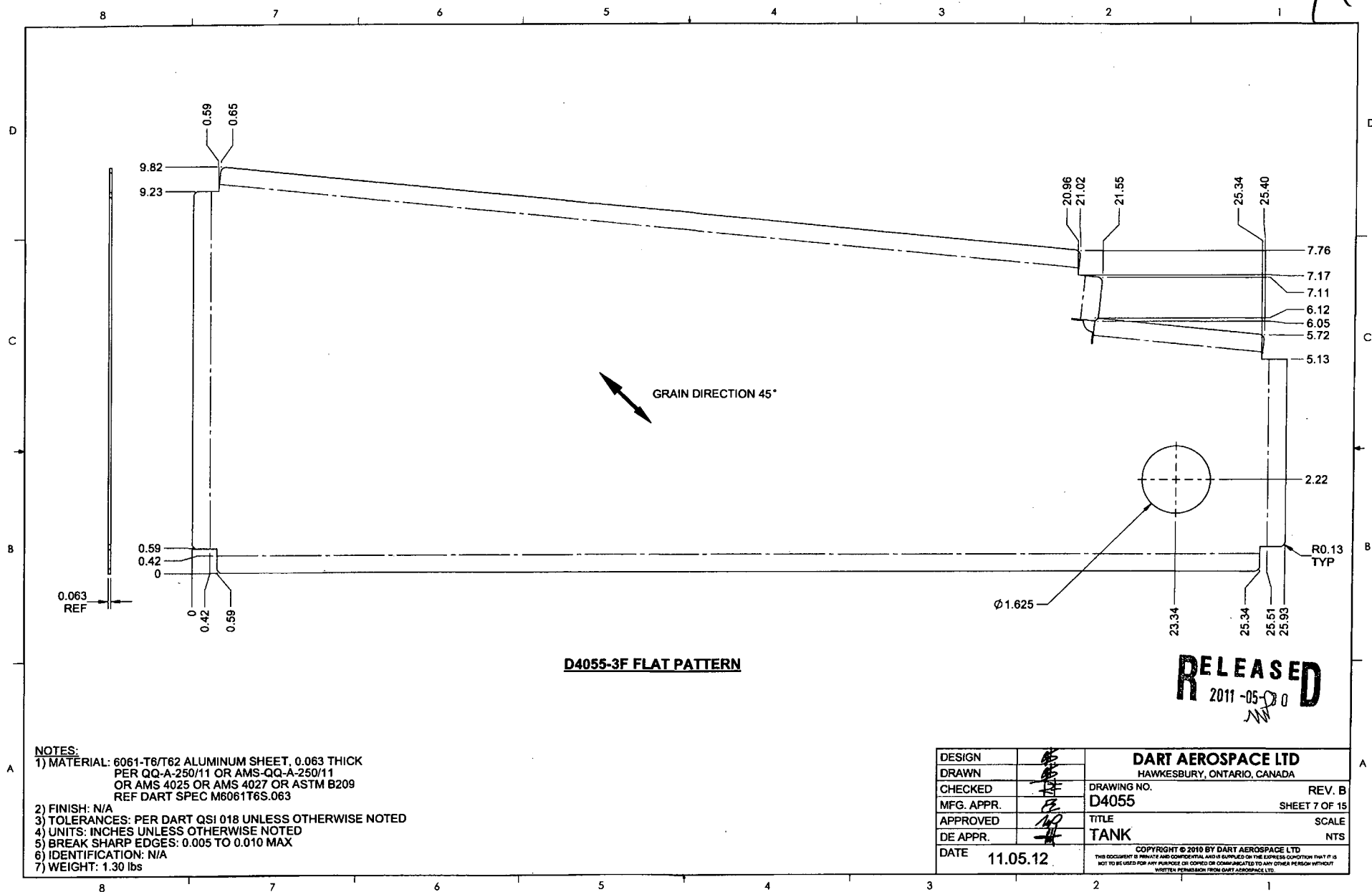
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806 74908



- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.30 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

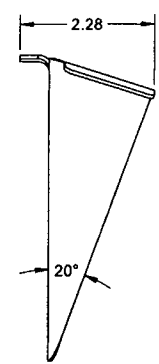
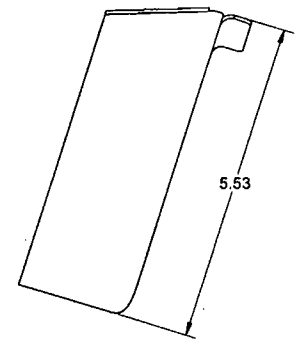
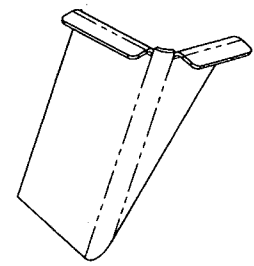
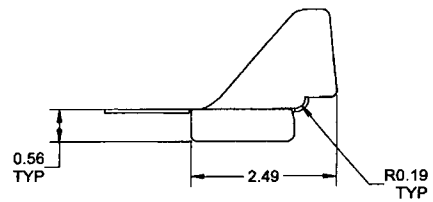
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


**NOTE:** Date & initial all entries







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74908



**D4055-5 UPPER CUT OUT**

**RELEASED**  
2011-05-30  
NW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-5F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.10 lbs
- 

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.		SHEET 8 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

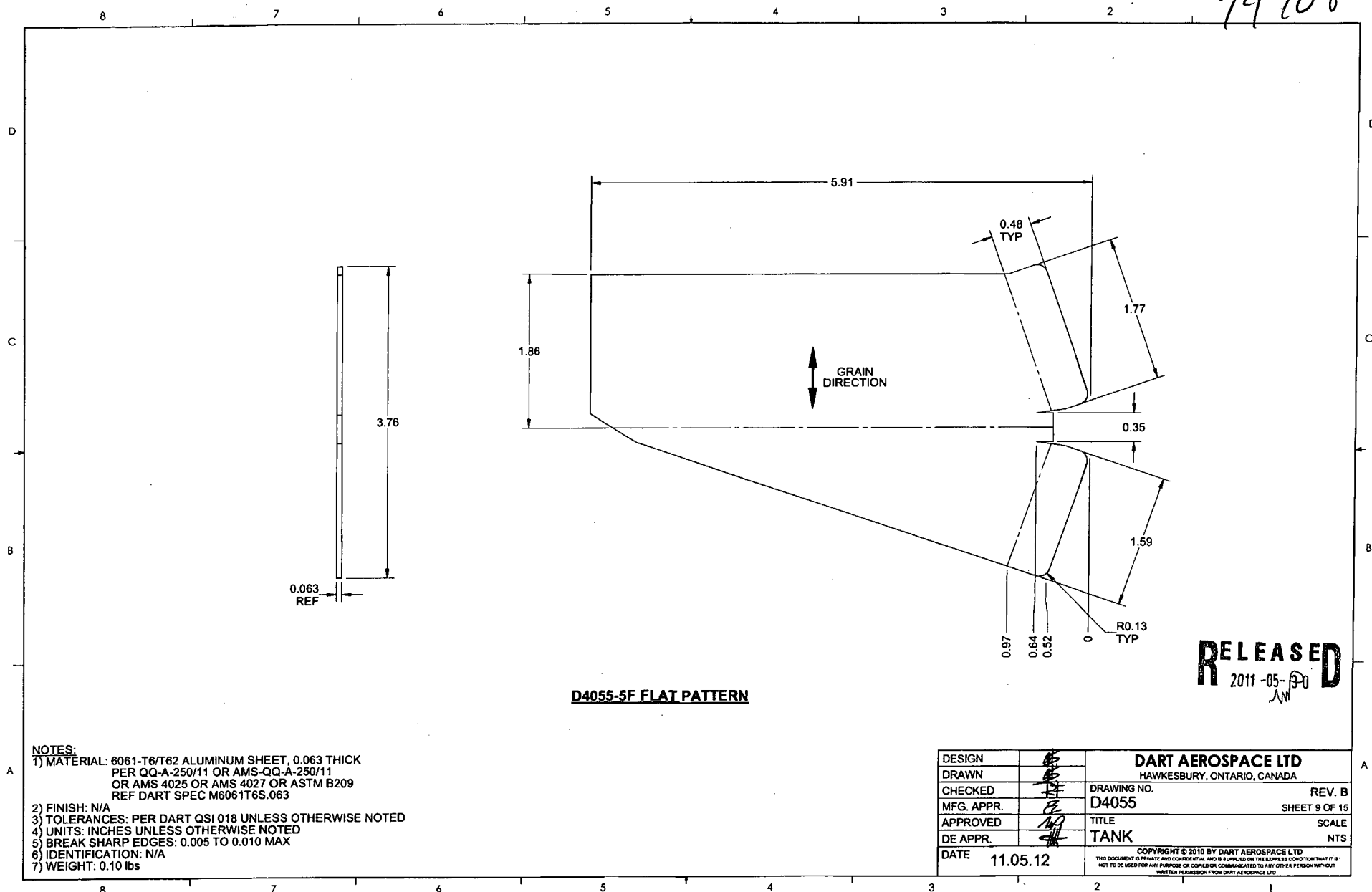
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









74806  
74908



RELEASED  
2011-05-30  
AN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 9 OF 15
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

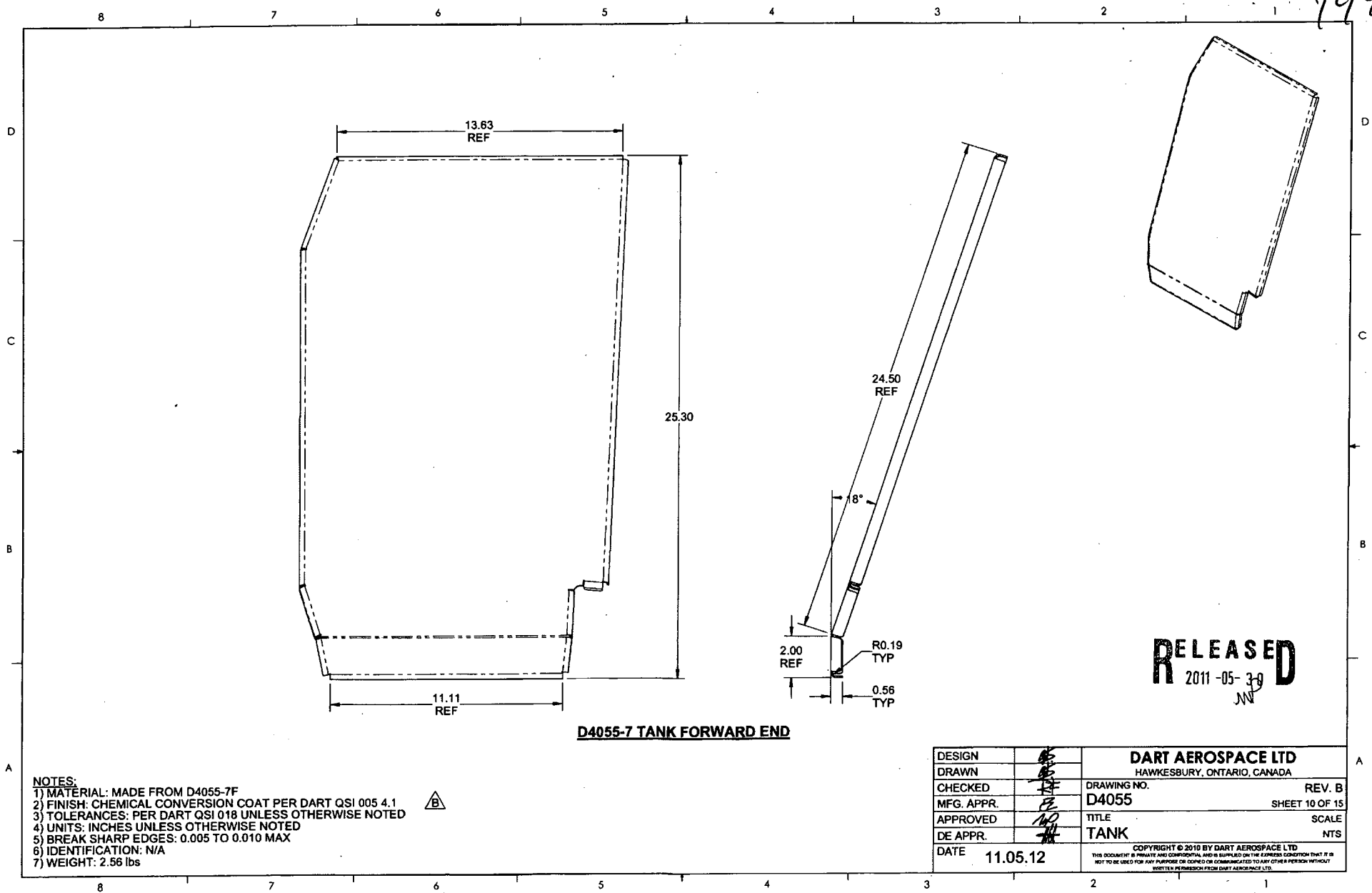
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806  
74908









**D4055-7 TANK FORWARD END**

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs



**RELEASED**  
2011-05-30  
NW

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4055</b>	SHEET 10 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

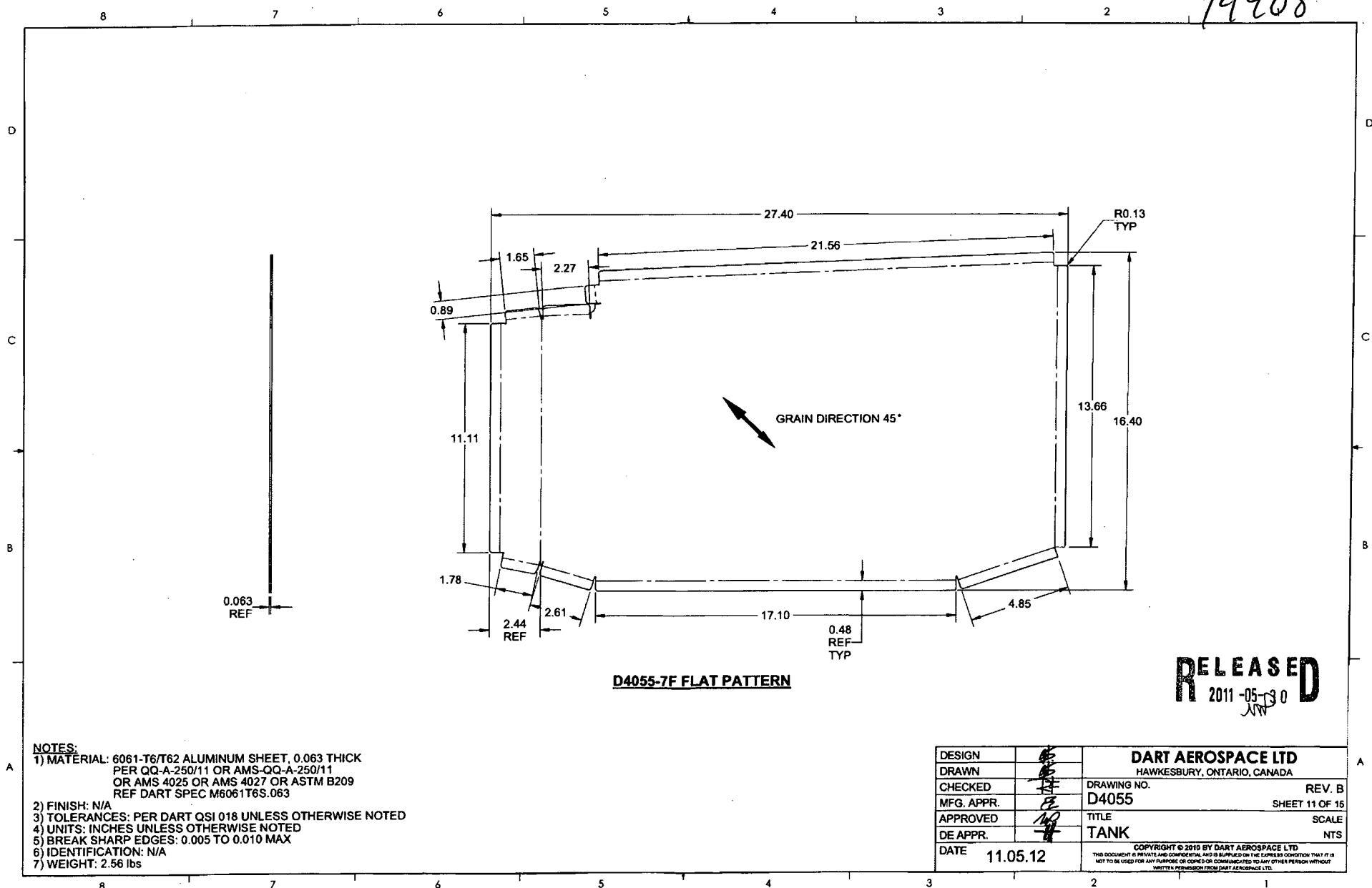
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806  
74908



**D4055-7F FLAT PATTERN**

**RELEASED**  
2011-05-30  
JTW

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.56 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

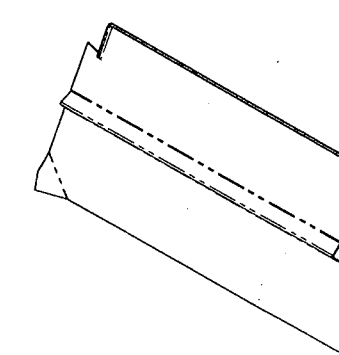
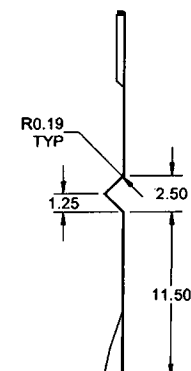
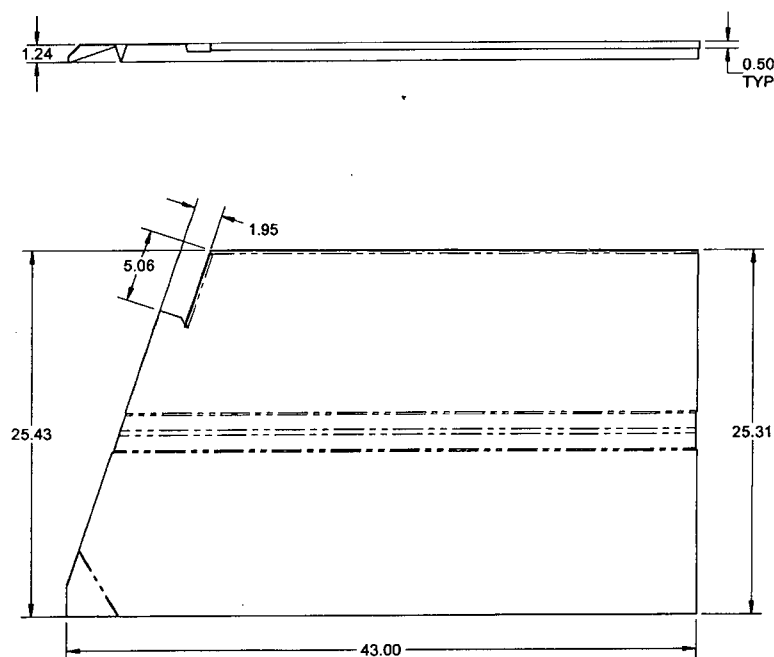
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806  
74908



**D4055-9 TANK BACK**

**RELEASED**  
2011-05-30

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

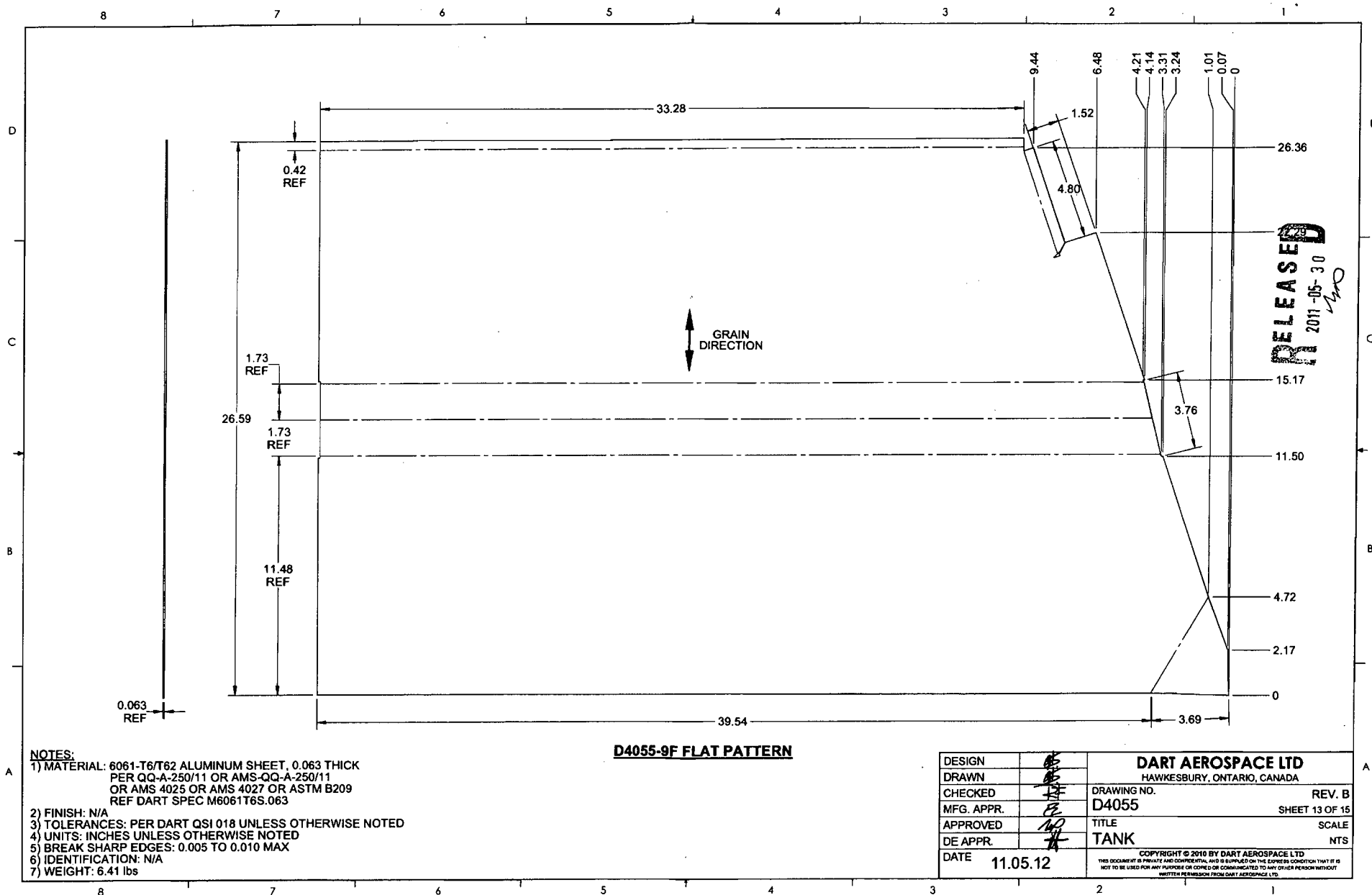
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



74908  
74806



RELEASED  
2011-05-30  
WFO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

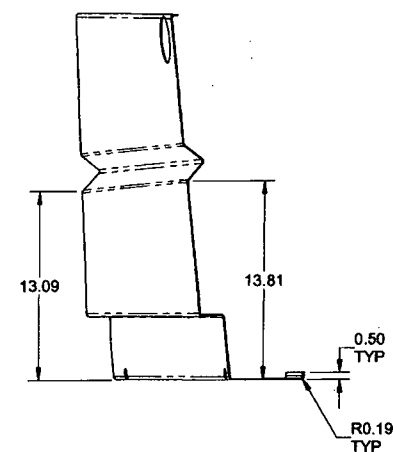
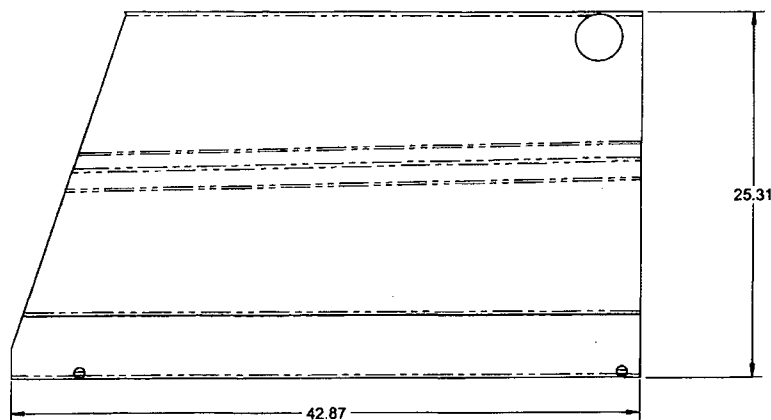
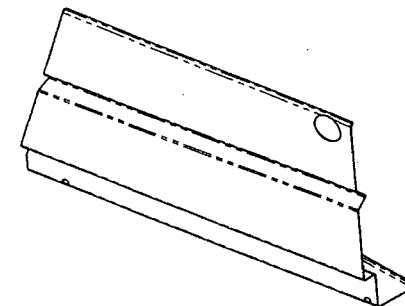
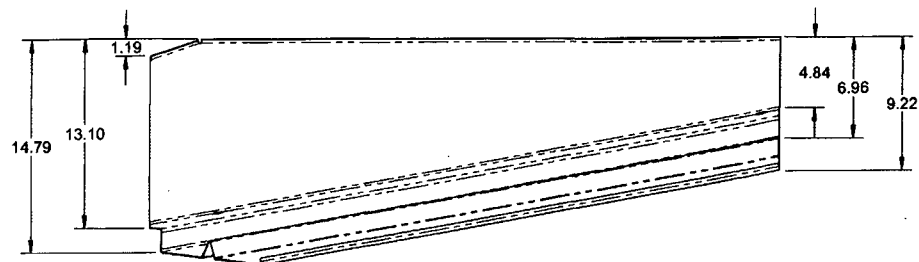
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74906 74806



**D4055-11 TANK FRONT AND BOTTOM**

**RELEASED**  
2011-05-30

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 9.32 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4055</b>	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

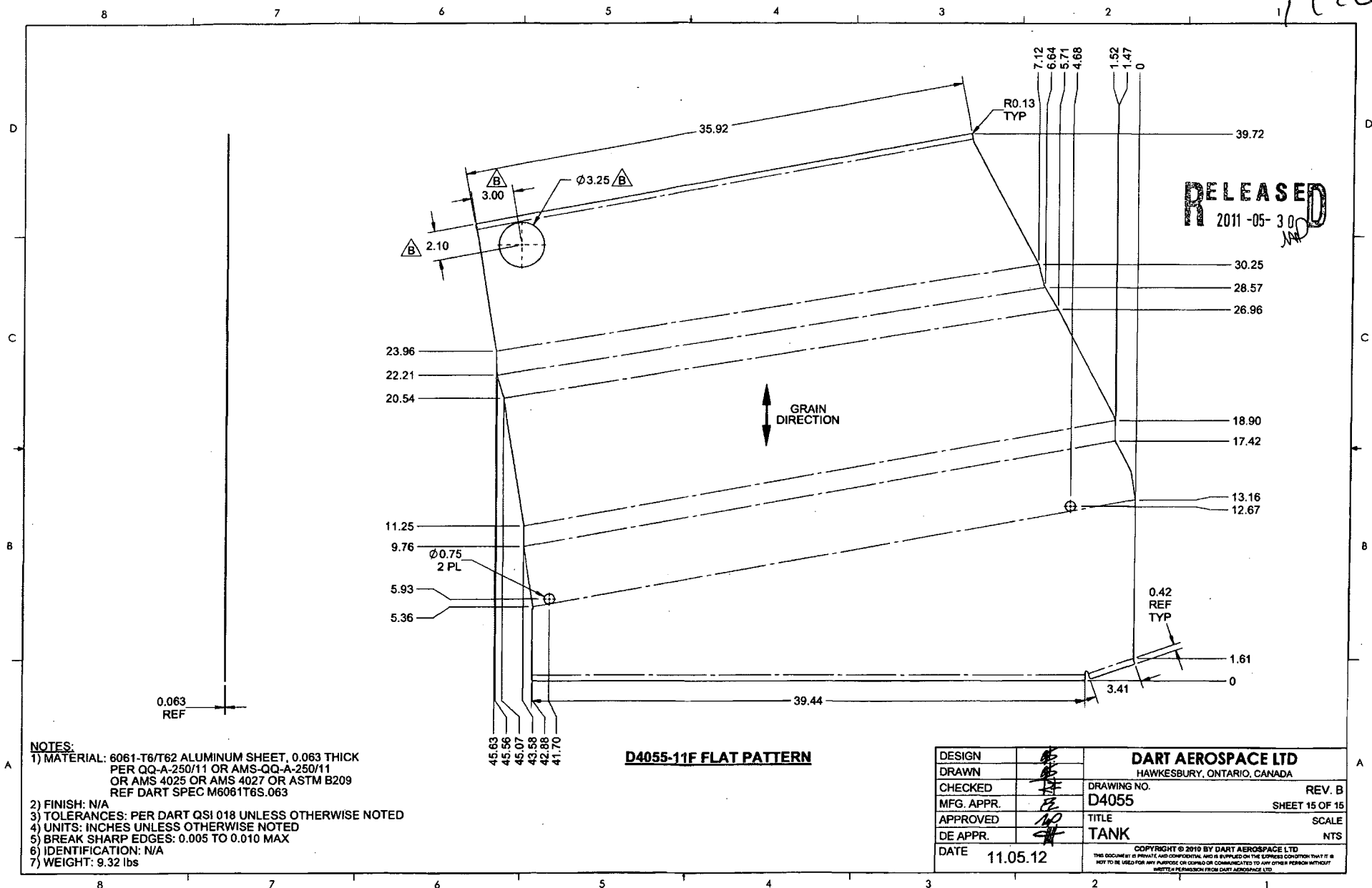
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74806 74906



- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 9.32 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO		PAGE
JR - DY	MO - MO	AN - YR			
31	10	11	0472876		1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART GFI-0299	0238304	PO15139	

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO	DESCRIPTION
5	D4055-11P	TANK FRONT AND BOTTOM CERTIFICATE OF CONFORMANCE REQ
MFG. JOB# _____ QTY _____		

EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO
----------------------	---



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>7</u>	OUR JOB NO	<u>J0238304</u>	SHIPPING MEMO	<u>0472876</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>-</u>	<u>5 PCS</u>	<u>PO15139</u>	<u>D4055-11P</u>	<u>B</u>	<u>TANK FRONT AND BOTTOM</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.063 THK AL 6061-T6</u> <u>(AMS-QQ-A250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>719924</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0238304-001 (5 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 31 OCTOBER 2011

G.F.I. Q.C. REP. *David Ansell*







Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9100B

### LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

**Date:** October 21, 2011

**Company Name:** GFI Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe-Claire, Qc  
**Zip Code:** H9R 1A1

**# du client:** 0079384

**Customer's order #:**

**# de commande SSMQ:** 087713  
**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Gauge/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.0630" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS4027	719924

Bien à vous,  
Yours truly,



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or other false fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy  
Director of Manufacturing Davenport Works

Terrence Thom  
Quality Assurance Manager

1292289  
Ship Date 0 B.L. No. Invoice No. Ship From: RIVERDALE, IA.  
2011-09-23 6372211 00000 Alcoa No. Item 1000300400-2 DCE-00400-2  
P.O. No./Govt Contract No. Customer Alcoa Item  
C63906 Ln#: 2 SAMUEL SON & CO LT G041110647R06

Page 1 of 2

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3T5 QC

Item Description  
0.063 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 -  
.125) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-  
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-  
209 REV 10 EXC MRK ASTMB209 REV 07  
CMMP025 REV S ((MARKED)) KRAFT PAPER  
INTERLEAVED MAX GROSS  
SKID WGT: 4500 LB QUAN TOL +/-30 %  
CQR 0222751 REV 05 CUST REQ 11-08-  
06 \*\*\* W/E 11-08-20 \*\*\*

*Jul 107*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	340127	719924	4033	100	PC	27592 46940
2	340135	719924	4075	100	PC	27592 46940
			8108	200		

Notes for CQR: 0222751.5  
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.5 -Specification Limits

Tmpt	Dir	UTS	TYS	EL4D
T6	Long Transv.	KSI	KSI	PCT
		Max		
		Min	42.0	35.0 10

# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

DAVENPORT WORKS 4878 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

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Malcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom  
Quality Assurance Manager

1292289

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2011-09-23

6372211

00000

1000300400-2

DCE-00400-2

P.O. No./Govt Contract No.

Customer

Alcoa Item

C63906 Ln#: 2

SAMUEL SON & CO LT G041110647R06

Page 2 of 2

CQR: 0222751.5 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy 6061		Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot: 719924		Min	0.40	0.15	0.8	0.04						
- Mechanical, Physical, Metallography, Quantometer Results												
Temp	Dir	No->	UTS	TYS	EL4D							
T6	Long Transv.	Test	KSI	KSI	PCT							
		2	50.2	44.5	11.6							
			50.2	44.3	11.7							

REMAIN

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H2797021	Actuals	0.64	0.4	0.23	0.04	1.0	0.16	0.02	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States